Monday, 2/5/2007 4:02:09 PM Kim Johnston **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 30648 - 2 Job Number 10313 Estimate Number MIA P.O. Number Part Number : D26483 S.O. No. : NA : 2/5/2007 - D2648 REV D This Issue Drawing Number : NC Prsht Rev. - N/A Project Number : 2/5/2007 SMALL /MED FAB First Issue Type Drawing Revision D : 29777 : 41/A Previous Run Material Due Date 2/23/2007 Qty: 200 Lm Written By Facil Checked & Approved By : Est E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF Est Rev.F Now on Waterjet 06-08 14 JLM Additional Product Job Number Seq. # Machine Or Operation: Description: 10 1010/1025/A21/6aA SHEET Comment: Otv 0.0788 sf(s)/Unit Total: 15.7500 sf(s) 1010/1025/A21/6aA SHEET (M1010S16GA) Batch: M 104056 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2648 Dwg Rev: D 97 04 24 Dwg Rev: D Prog Rev: 1 2-Deburr if necessary Q02 INSPECT PARTS AS THEY COME OFF MACHINE 10:04 24 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 40 SECOND CHECK Comment: SECOND CHECK SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: 07605/3/
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Date: Monday, 2/5/2007 4:02:09 PM User: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: WEARPAD Job Number: 30648 Part Number: D26483 Job Number: Seq. #: Machine Or Operation: Description: BRAKE NO NC BRAKE 6.0 Comment: NC BRAKE 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D2648-3 LAPGE FAR 1 LARGE FAURICATION RESOURCE 1 70 Comment: LARGE FABRICATION RESOURCE 1 QIV. Description Batch A/R560Hardcoat 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary 009 80 VISUAL WELDING INSPECTION Comment: VISUAL WELDING INSPECTION 005 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 10.0 FOWDER COATING POWDER COATING m 101601 Comment: POWDER COATING Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 120 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock 13.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE 07/05/3 Job Completion

Page 2

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W/O:		WORK ORDER CHA	NGES				
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			QA:	N/C Close	d:	_ Date: _	1 5

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC	Corrective Action Section B			Verification		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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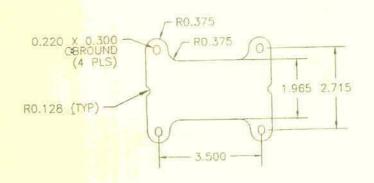
DART AEROSPACE LTD	Work Order:	30648
Description: Wearpad	Part Number:	D2648-3
Inspection Dwg: D2648 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	×	First Article		Protot		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.965	+/-0.010	1.971	1		Wern.	
2 715	4/-Q.010	2.718	1		Vern	-
3.500	+/-0.010	3.504	1		VEEN	
0.220 x 0.300	+/-0.010 x +/-0.010	0.220x0.300	1.		Vern	
R0.375	+/-0.010	K 0.375	1		RAD is GUAGE	
R0.128	+/-0.010	10.128	V		Rediss Gorge	
asured by:	M-M 07-04 24	Audited by:	1/04/2	5	Prototype Approx	val: N/A
ev Date	Change		1-10			
06,10.16	New Issue				Revised KJ/JLM	Approved

Dart Aei	rospace	e Ltd							
W/O:			V	ORK ORDER CHANGES	3				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cat	egory:I				_ Date: _	
NCR:		V	VORK ORI	DER NON-CONFORMAN					
DATE	0755	Description of NC		Corrective Action Section E		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section		Chief Eng	QC Inspector
	-								xdi

D2648-1 FLAT PATTERN



R1.62

R1.62

7560 HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.063 TO 0.125 THICK
0.

DS

R1.62

D2941-300

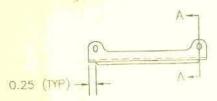
REMOVE POWDER

COAT FROM THESE

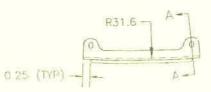
SURFACES

SECTION B-B

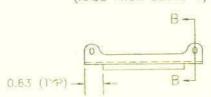




(MADE FROM D2648-1)



(MADE FROM D2648-1)







EREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 0.05
TOLERANCES ARE PER DART QSI 0.18 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

D	99.11.17	ADDED D2648-7			
C	97.06.26	R31.6 WAS R19.6			
В	97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250			
A	97,03.25	NEW ISSUE			
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC			
ENECOSE !!!	AF-PROVALE	DEAMING NO. REV.			
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W/O:			٧	VORK ORDER CHANGES				
DATE	STEP	PROC	HANGE	Ву	Date G	Approval Chief Eng / Prod Mgr	Approval I QC Inspector	
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Part No			-16	DER NON-CONFORMANCE	QA: N/	C Closed: _	Date: Date: _	
			Corrective Action Section B				±.00.00	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Construction Const		Approval QC Inspector
				*				